

Date: Monday, 17/11/2008 10:38:58 AM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206L AFT X-TUBE
<b>Job Number</b> :	43475		
<b>Estimate Number</b> :	10973		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206667203BL
<b>This Issue</b> :	17/11/2008	<b>Drawing Number</b> :	D206-667-243 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	
<b>Previous Run</b> :	43473	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	10/01/2009
<b>Checked &amp; Approved By</b> :	<i>Julie Dawson</i>	<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec Est Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

*5 09/10/08*

2.0	D206667203TRN	Crosstube Turning Detail
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**Comment:** Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *6-43528*

*D/MB 08-12-08*

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

*D/MB 08-12-08*

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

*08-12-08*

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

*D/MB 08-12-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 43475

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description:

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243  
Inside of Cuff (Do not engrave on outside of tube)

IT/MB  
08-12-09

AWM  
08-12-10  
MB  
08-12-09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-12-09



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/12/11 (S)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/11 (S)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



P107874  
08/12/11 (S)



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

S 08/12/11 (S)

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Drawing Name: 206L AFT X-TUBE

Job Number: 43475

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QCS  
S AS

DIMENSIONAL CHECK



ml 08 12 19

(1)



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY B110161

ml 09/01/05 (1)

2-

-PAINT DELFLEET BLUE B110077

-CLEAR DELFLEET B110161

13.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 09-01-06

14.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2- D2873-045

Nut Plate

42784

RT 08-12-22

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

43176

RT 08-12-22

16.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

108076<sup>rb</sup>/110219

RT 08-12-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43475

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 08-12-22

18.0	D3595075450	RUBBER CUSHION .75" x 4.50
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION .75" x 4.50

B 41108

RT 09-01-06

19.0	D28921	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support 43385

RT 09-01-06

20.0	MS2192022	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp 108187

RT 09-01-06

21.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

RT 09-01-06

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 09-01-07

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 09/01/07 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43475

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

24.0 AN534A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109061 x1 M109752 x3

SS 09/01/07 (X)

25.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

SS 09/01/07 (X)

26.0 AN510A Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M109752.

SS 09/01/07 (X)

27.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M110363

SS 09/01/07 (X)

28.0 AN960JD516 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109752

SS 09/01/07 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43475

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S. 08/10/08

30.0

PACKAGING 1

PACKAGING RESOURCE #1



MF

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

D

MF

S

31.0

QC21

FINAL INSPECTION W/O RELEASE



MF

Comment: FINAL INSPECTION W/O RELEASE

D 09/01/09

Job Completion



MF 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

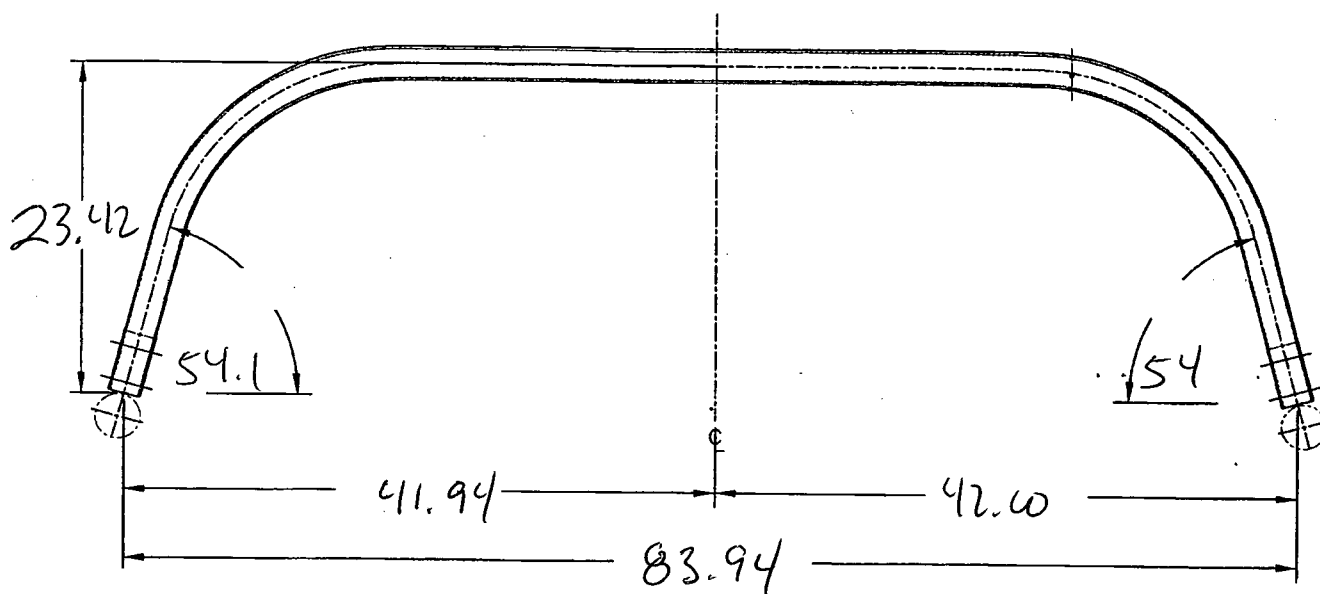
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43425
<b>Description:</b> Crosstube High Aft (206L)		<b>Part Number:</b> D206-667-203
<b>Inspection Dwg:</b> D206-667-243	<b>Rev:</b> B	<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	06.12.08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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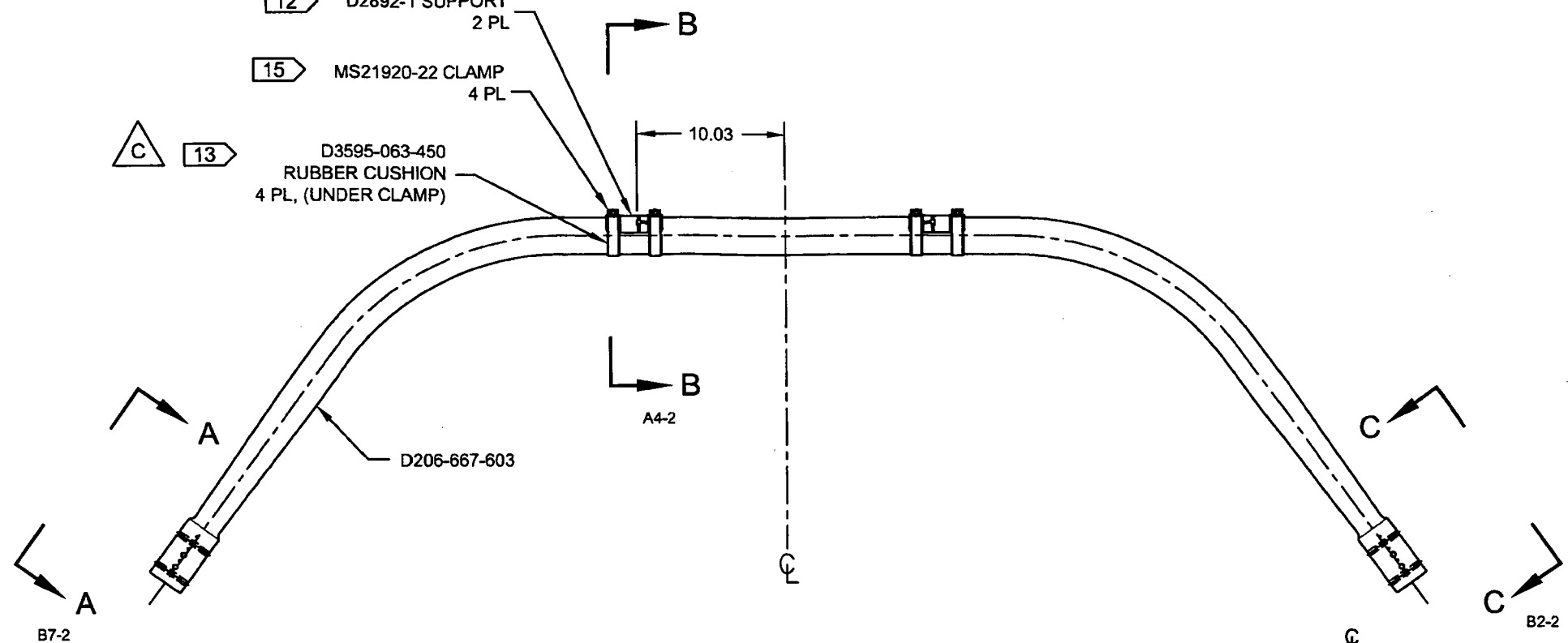
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

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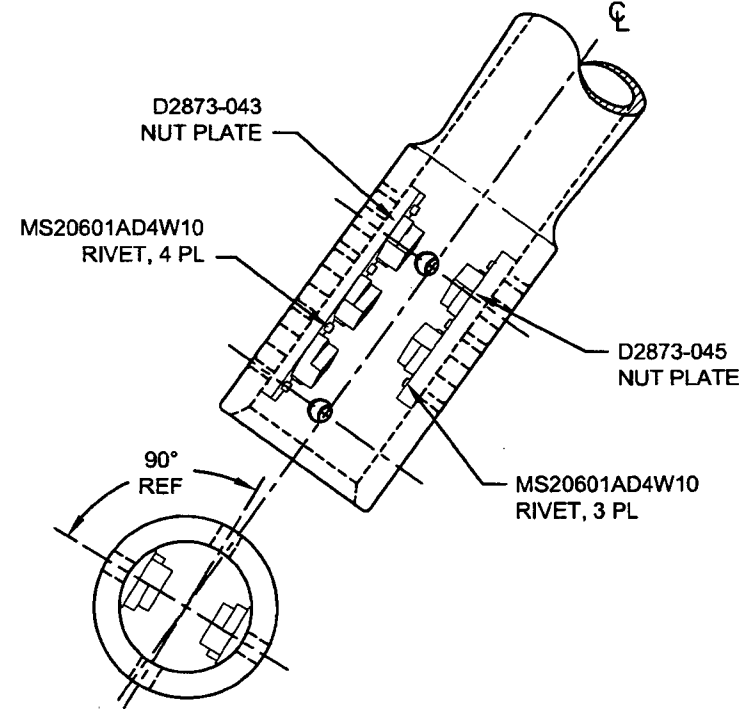
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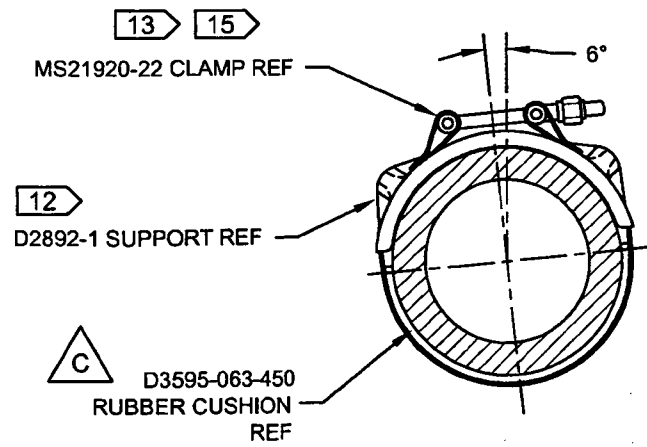
- 12 D2892-1 SUPPORT 2 PL
- 15 MS21920-22 CLAMP 4 PL
- 13 D3595-063-450 RUBBER CUSHION 4 PL, (UNDER CLAMP)



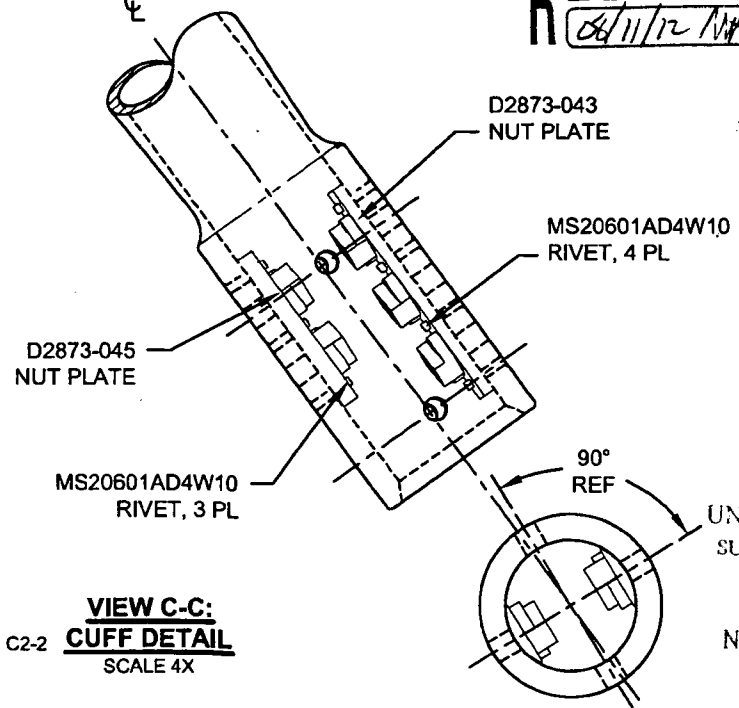
**D206-667-243**  
**ASSEMBLY DETAIL**  
(VIEW LOOKING FWD)



**VIEW A-A:**  
**CUFF DETAIL**  
SCALE 4X



**SECTION B-B**  
SCALE 5X



**VIEW C-C:**  
**CUFF DETAIL**  
SCALE 4X

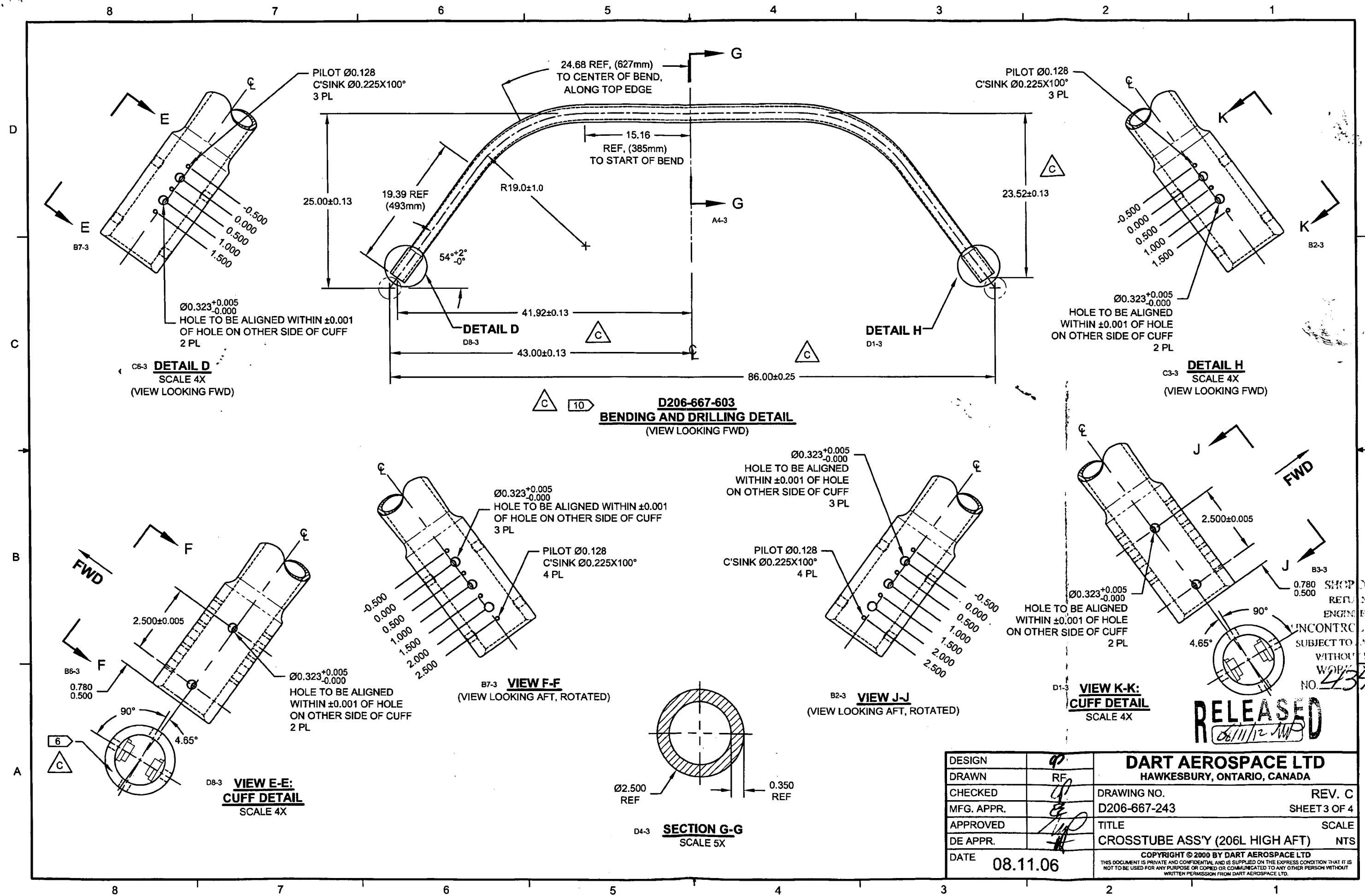
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WORK ORDER NO. 43475

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	2	D206-667-243	SHEET 2 OF 4
APPROVED	3	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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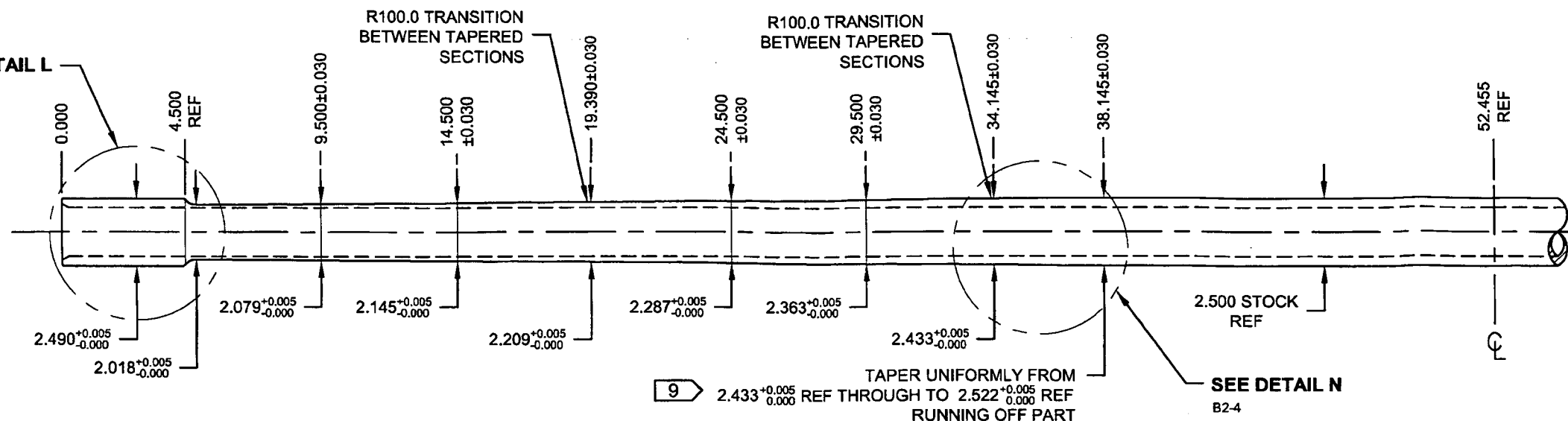




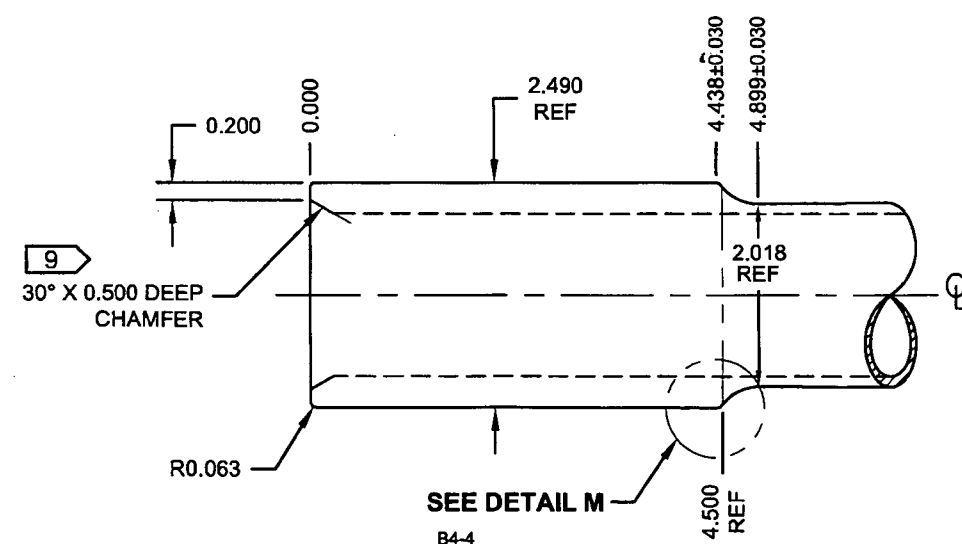


DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. C
MFG. APPR.	4	D206-667-243	SHEET 3 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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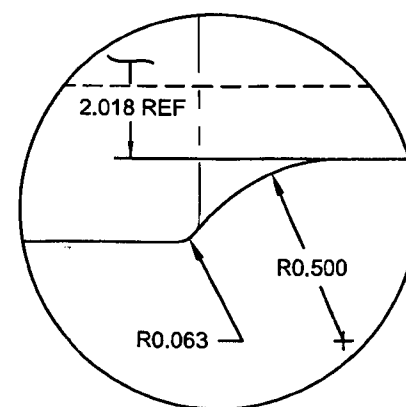
SEE DETAIL L  
B7-4



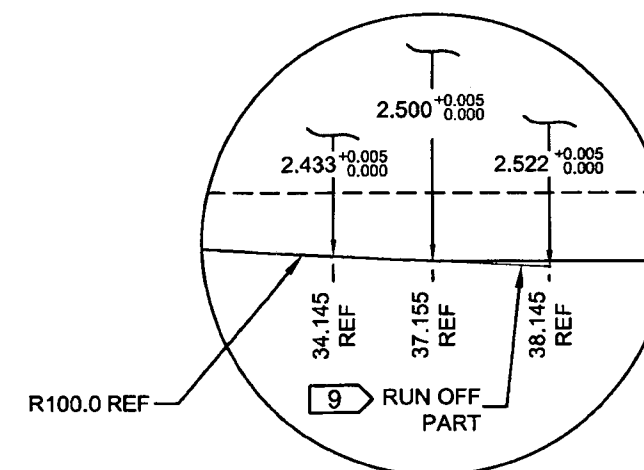
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43475

**RELEASED**  
08/11/06

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	EF	D206-667-243	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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PT Sept 2005

Date: Wednesday, 19/11/2008 9:00:50 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L AFT X-TUBE
<b>Job Number</b>	: 43475		
<b>Estimate Number</b>	: 10973		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206667203BL
<b>This Issue</b>	: 19/11/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D206-667-243 REV B
<b>First Issue</b>	: 17/11/2008	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43473	<b>Drawing Revision</b>	:
		<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 10/01/2009
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec Est Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC		

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JUD 08.12.05



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0	D206667203TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch \_\_\_\_\_

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT \_\_\_\_\_

Job Completion

